

Date: Wednesday, 14/01/2009 9:01:27 AM  
 User: Melanie Fauteux

## Process Sheet

NOT P. Att D.S.

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LARGE BUBBLE WINDOW KIT, LH  
 Job Number : 44748  
 Estimate Number : 13717  
 P.O. Number :  
 This Issue : 14/01/2009 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL /MED FAB  
 Previous Run :  
 Part Number : D412761045  
 Drawing Number : PRELIM  
 Project Number : N/A  
 Drawing Revision : PRELIM  
 Material :  
 Due Date : 19/01/2009 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : MF 09-01-124  
 Comment : Est Rev:A 09-01-13 rev.C as per dwg DD verified by:EC



Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP D412-761-045 CHG001



2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit



3.0 D36761 BUBBLE WINDOW



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BUBBLE WINDOW

batch: 4144 Daryl



4.0 D36781 Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Placard

batch: 46354

sent later mf 09-01-16



5.0 D37001 Inboard Window Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Inboard Window Doubler

batch: B44599

1/88 09/01/16



5.1 ~~ASST~~ DT9458 09.06.09

Qty: 1

cutting template

Batch: N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 14/01/2009 9:01:27 AM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LARGE BUBBLE WINDOW KIT, LH

Job Number: 44748

Part Number: D412761045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D37003

Outboard Window Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Outboard Window Doubler

batch:

44600

1 SS 09/01/16 (X)

7.0

D37011

Floor Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Floor Doubler

batch:

05061

1 SS 09/01/16 (X)

8.0

D37021

Fwd Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Fwd Doubler

batch:

B44598

1 SS 09/01/16 (X)

9.0

D37031

Aft Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Doubler

batch:

05062

1 SS 09/01/16 (X)

10.0

D37033

Aft Corner Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Corner Doubler

batch:

B44596

1 SS 09/01/16 (X)

11.0

D37035

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

batch:

B44597

1 SS 09/01/16 (X)

12.0

D37041

ESCUTCHEON



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

ESCUTCHEON

batch:

44761

1 SS 09/01/16 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LARGE BUBBLE WINDOW KIT, LH

Job Number: 44748

Part Number: D412761045

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D37081

Angle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Angle

batch:

B05063

1/SS 09/01/16 EC

14.0

D37083

Angle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Angle

batch:

B05064

1/SS 09/01/16 EC

15.0

D37091

Angle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Angle

batch:

B05065

1/SS 09/01/16 EC

16.0

D37093

Angle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Angle

batch:

B05066

1/SS 09/01/16 EC

17.0

D38021

Window Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Window Seal

Cut seal 135.00" long batch:

44630

1/SS 09/01/16 EC

18.0

AN37A

Bolt



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)

Bolt

batch:

M5288 X-12

-14

1/SS 09/01/16 EC

19.0

AN960JD10

Washer



Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s)

Washer

batch:

M69001

1/SS 09/01/16 EC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

Date: Wednesday, 14/01/2009 9:01:27 AM  
User: Melanie Fauteux

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LARGE BUBBLE WINDOW KIT, LH

Job Number: 44748

Part Number: D412761045

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

MS21042L3

Nut



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)

Nut

batch: M168816

1 / SS 09/01/16 CR

21.0

MS24694C5

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screw

batch: M166815

1 / SS 09/01/16 (X1)

22.0

MS24694C13

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screw

batch: M168568

1 / SS 09/01/16 (X1)

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

ENGINEERING  
APPROVAL

09.01.16

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-761-045

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

transfer  
Dart Calgary

~~DON'T KNOW WHERE IT IS~~

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

u 09.01.20

09.01.16

u

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Wednesday, 14/01/2009 3:14:03 PM  
User: Linda Lacelle

Process Sheet

DUPLICATE

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 41414  
Estimate Number : 13138  
P.O. Number :  
This Issue : 14/01/2009 S.O. No. :  
Prsht Rev. : NC  
First Issue : 19/08/2008 Type : THERMOFORMING  
Previous Run : 41413

Drawing Name : BUBBLE DOOR 412 VERTIGLE REFERENCE  
Part Number : D36761  
Drawing Number : D3676  
Project Number : 00224  
Drawing Revision : B Preliminary  
Material :  
Due Date : 26/08/2008 Qty: 3 Um: Each

POSITIVE  
RECALL

Written By :  
Checked & Approved By : MF 09-01-14  
Comment : Est. Rev A New Product 01/24/2008 DL Verified:JLM

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MACRLICS250 5236 Plexiglass G .250



Comment: Qty.: 13.0000 sf(s)/Unit Total: 26.0000 sf(s)  
0.250" PLEXIGLAS G CLEAR CAST ACRYLIC SH

M 107871 x2  
1) Batch # M107877 x3

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Set up Machine as per folio FTA 018 and D3676 program

09/01/20

3.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks to 30" by 48"

09/01/20

4.0 THERMOFORMING THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3676 and Folio FTA 018

Dwg. Rev. B PRELIMINARY.  
Folio Rev. B

09/01/21

(X5) - PTO

> >

# Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: BUBBLE DOOR 412 VERTICLE REFERENCE

Job Number: 41414

Part Number: D36761

Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check depth of bubble to ensure conformity to drawing tolerances.

6.0

QC8

SECOND CHECK

ENGINEERING  
APPROVAL

Comment: SECOND CHECK

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING

Comment: HAND FINISHING THERMOFORMING

1) Trim off excess flange material

2) Buff out any light scratches or blemishes

3) Etch part number and batch number

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

9.0

QC5

INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

1) Visually inspect for clarity, and proper formation.

10.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

11.0

QC21

FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Completion

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE